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DATE 05.04.01	TITLE LANDING LIGHT MODIFICATION		SCALE NTS
A	05.04.01	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 Rev.C

& SERVICE INSTRUCTION DSI 9282 Rev. A

REF. CANADIAN STC: SH92-18 ISSUE 5

REF. FAA STC: SH989NE / SH990NE

Contrary to DSI 9282, the D350-567-111 Vertical Reference Window Kit can be made compatible with the 355A64-7047-38 (or equivalent) Landing Light by relocating the light as shown below. Follow the installation procedure on page 2 of this service instruction.

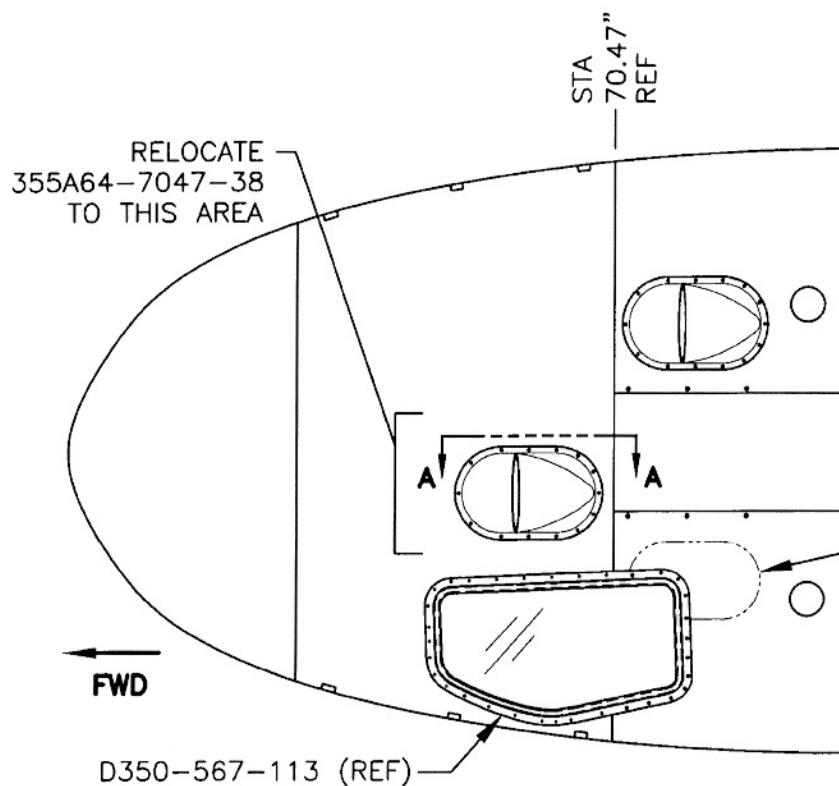
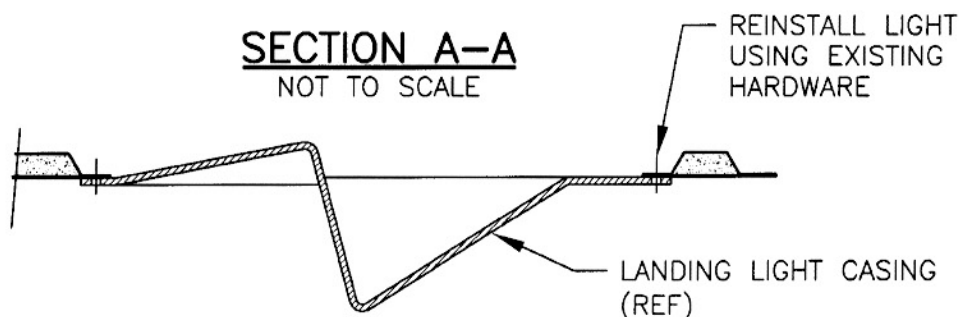


FIGURE 1

VIEW LOOKING UP AT
UNDERSIDE OF AIRCRAFT

OLD LOCATION OF
355A64-7047-38,
PATCH HOLE PER THESE
INSTRUCTIONS PRIOR TO
INSTALLATION OF WINDOW
PER D350-567 REV. C
AND DSI 9282 REV. A

SECTION A-A NOT TO SCALE



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 05.04.01
CERT. NO.: SH92-18
ISSUE NO.: 5

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DATE 05.04.01		TITLE LANDING LIGHT MODIFICATION	SCALE NTS

MODIFICATION INSTRUCTIONS

PRIOR TO INSTALLING THE DART D350-567-113 WINDOW KIT ON AIRCRAFT EQUIPPED WITH 355A64-7047-38 (OR EQUIVALENT) LANDING LIGHT, PERFORM THE FOLLOWING MODIFICATION:

Remove Hardware:

- (1) Remove the 355A64-7047-38 landing light, associated attachment hardware, 350A21-0024-00A1 (or equivalent) fairing, and 350A21-0025-02 (or equivalent) fairing.

Fill Existing Landing Light Hole (see Figure 2 for reference):

- (2) Attach a backing plate with release film to outside surface of fairing to match fairing curvature. An aluminum sheet and release film taped on with Teflon tape is recommended.
- (3) For fiberglass modifications in these instructions use the following materials:
 - (i) 9 oz cloth: 9.7 oz. 7781 "S" Glass Universal Weave, OR equivalent.
 - (ii) Adhesive/Resin: EPOCAST 50-A/9816 (CIBA GEIGY), EPOCAST 6121, Macrobond 6398, or Hysol EA9309-3NA / EA9300 / EA9330.3 / EA9359.3
 - (iii) Adhesive paste: Mixture of adhesive, Milled Fibers E-Glass (CIBA GEIGY), and K20 Glass Bubbles (3M), OR 5 minute epoxy, OR equivalent.
- (4) Fill landing light attachment holes with adhesive paste (see Figure 2).
- (5) Lay up 1 layer of 9 oz. cloth on inside surface of fairing, covering part of the cutout and surrounding area shown in Figure 2. Cut and lay up 2 layers of 9 oz. cloth inside the cutout to match the contour in the fairing. Lay up 2 layers of 9 oz cloth to form new inside skin, staggering the size of each cloth, with the final piece covering an area 2" around the cutout. Cure at room temperature for 24 hours.
- (6) Remove the backing plate. Lay up 1 layer of 9 oz. cloth covering and surrounding the newly filled cutout to create a new outside skin. An area 2" around filled cutout should be covered as shown in Figure 1. Cure at room temperature for 24 hours.

Install Landing Light at New Location (see Figure 1 & 3 for reference):

- (7) Position the landing light in its new location (see Figure 1). Mark the location of the landing light's outer casing (this may be easier using a template). Remove the casing or template and cut fiberglass 1.00" from edge of landing light casing, as shown in Figure 3.
- (8) Trim foam in a 0.75" perimeter around newly cut hole at a 30° angle and apply 2 layers of 9 oz cloth covering an area 2.0" around the cut-out as shown in Figure 3. Cure at room temperature for 24 hours.
- (9) Transfer drill Ø0.250 holes for attachment hardware using landing light casing or a template.
- (10) Touch up paint per the Aircraft Maintenance Manual to match original finish.
- (11) Install D350-567-113 per service instruction DSI 9282 (if not already installed).
- (12) Re-install Landing Light using existing hardware.

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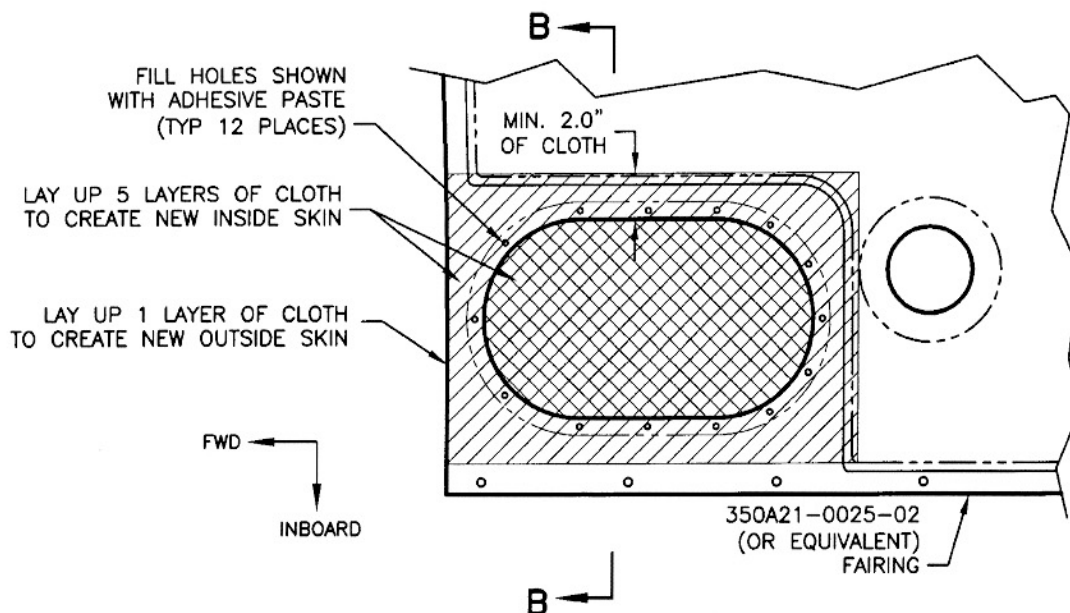
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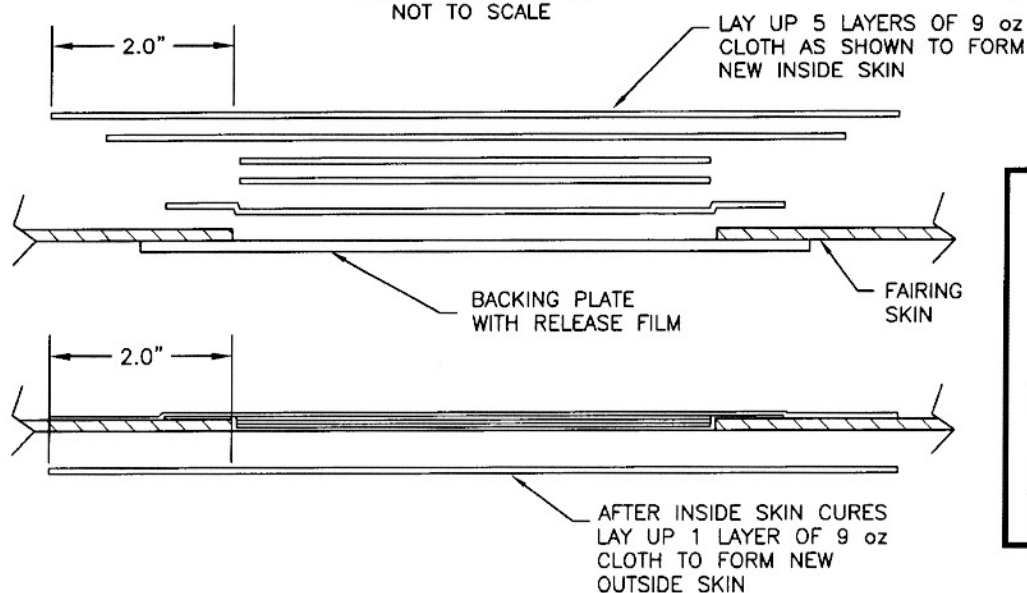
FIGURE 2: FAIRING MODIFICATION, OLD LOCATION

VIEW LOOKING DOWN AT INSIDE OF 350A21-0025-02 (OR EQUIVALENT) FAIRING



SECTION B-B

VIEW ROTATED 90° CW
NOT TO SCALE



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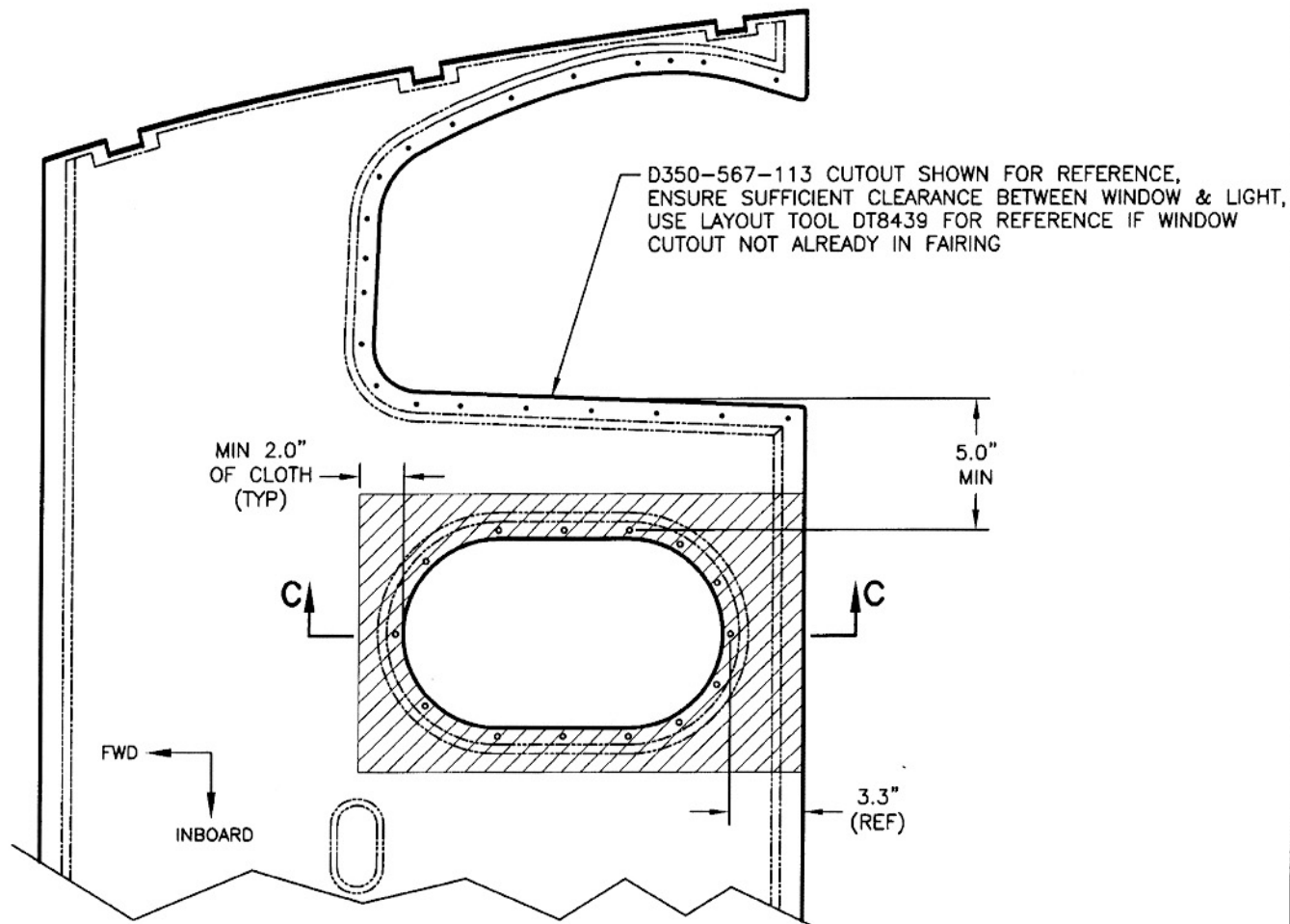
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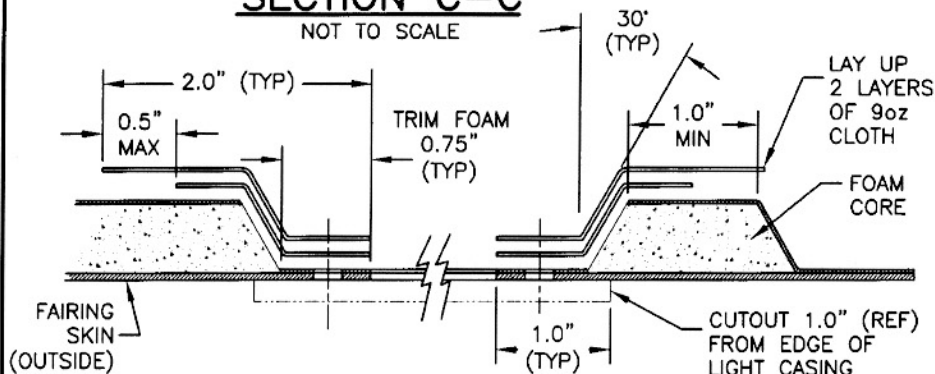
FIGURE 3: FAIRING MODIFICATION, NEW LOCATION

VIEW LOOKING DOWN AT INSIDE OF 350A21-0024-00A1(OR EQUIVALENT) FAIRING



SECTION C-C

NOT TO SCALE



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